DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-002464
Date Inspected: 20-Apr-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1400
OSM Departure Time: 2330
Location: Shanghai, China

CWI Name:	N/A		**CWI Present:**	☐ Yes	☑ No
Inspected CWI report:	☐ Yes	☐ No ☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No ☑ N/A
Electrode to specification:	☐ Yes	☐ No ☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No ☑ N/A
Qualified Welders:	☐ Yes	☐ No ☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No ☑ N/A
Approved Drawings:	☐ Yes	☐ No ☑ N/A	**Approved WPS:**	☐ Yes	☐ No ☑ N/A
			Delayed / Cancelled:	☐ Yes	☑ No ☐ N/A

Bridge No: 34-0006
Component: OBG

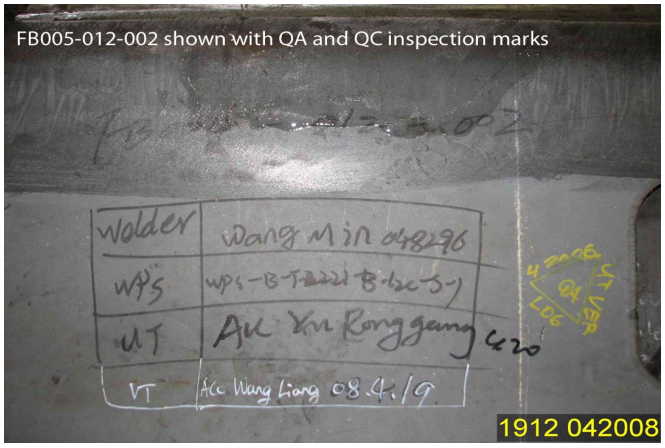
Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Bay 7- QA Inspector witnessed ZPMC QC UT inspectors Mai Ji Long and Xu Rong Gang perform UT testing on floor beam sub assembly welds. QA inspector performed ultrasonic (UT) verification testing of floor beam sub assembly Complete Joint Penetration (CJP) welds at joints FB004-009-002, FB004-013-020, FB004-010-002 & 020, FB004-012-002 & 020, FB004-013-020, FB004-014-002 & 020, FB005-007-002 & 020, FB005-008-002 & 020, FB005-009-002 & 020, FB005-010-002 & 020, FB005-011-002 & 020, FB005-012-002 & 020, FB005-013-002 & 020, FB005-014-002 & 020, FB005-015-002 & 020, FB014-014-002 & 020, FB014-015-002 & 020 after ZPMC QC acceptable UT inspection. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated April 20, 2008. QA Inspector found QC UT inspection method and welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer